

Work Order ID 132796

May-07-15 2:23:11 PM

132796

Page 1

Item ID: D2171 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 5/07/15 Start Qty: 18.00 ***18*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 18.00 ***18*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2171	Rev D

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100 PURCHASING 40 0 Jm15-5-11
 Waterjet

FLOW CNC Waterjet **Memo** 0.00
304.063 1-Cut as per Dwg
 Dwg Rev: 8
 Prog Rev: _____

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110 40 0 Jm15-5-11
 QC

Quality Control **Memo** 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 132796***132796***

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Item ID: D2171

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp

Start Date: 5/07/15

Start Qty: 18.00

18

Cust Item ID:

Required Date: 5/07/15

Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(40)

DAS
38
9-89

MAY 11 2015

130

Form as per dwg

0.00

130

Brake NC

Memo

0.06

Brake NC

1- remove press and machine marking as necessary

DAS
30
9-89

40

MAY 12 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(40)

DAS
38
9-89

MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order ID 132796

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132796

Page 3

Item ID: D2171 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 5/07/15 Start Qty: 18.00 ***18*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 18.00 ***18*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>stsyd</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

40
 MAY 19 2015

MLJ MAY 19 2015

MLJ MAY 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

May-07-15 2:23:10 PM

Page 1

Work Order ID: 132796

132796

Parent Item: D2171

D2171

Parent Item Name: Clamp

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	318.7176	0.0258	0.488842			
M304S16GA										**	①	Jm15-5-11	
304/316 Sheet .063													
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				MAT019				318.7176					
				m131384				121.4176					
				m131503				197.3			<u>131503</u>		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

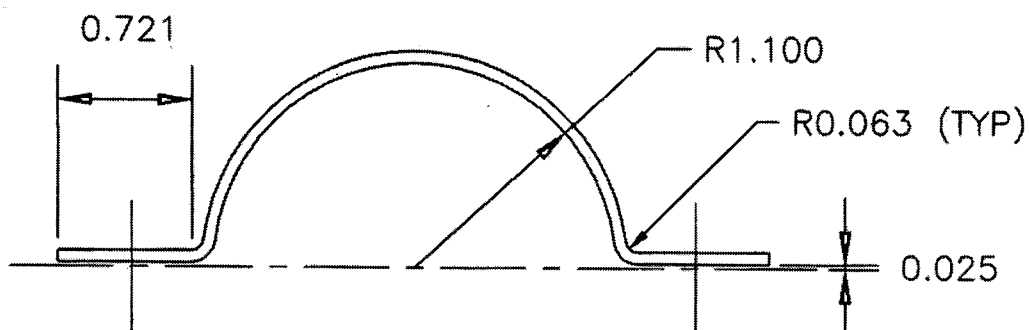
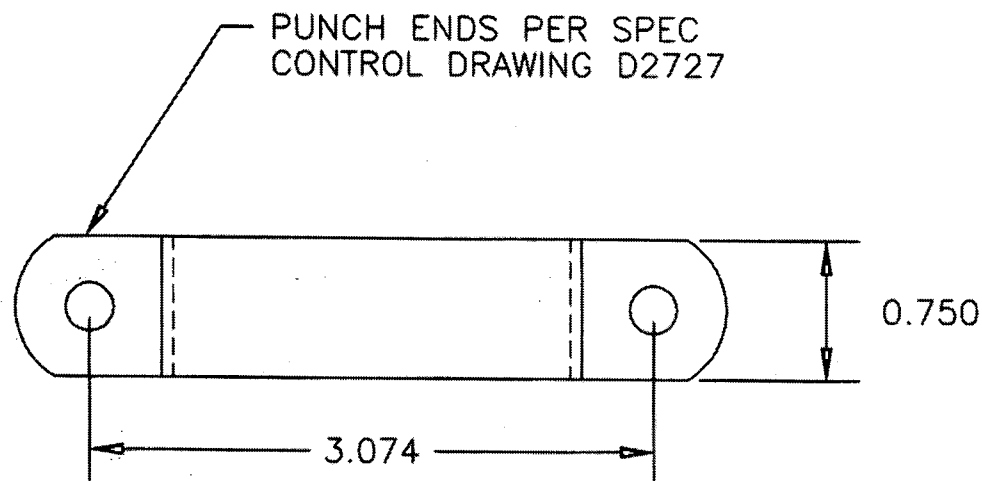
Work Order update only ☐

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OTHER : ☐					



DESIGN BW	DRAWN BY DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4,888	

RELEASED
99.03.11 KE



MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



132796 MCT
150508

100% COPY
100% COPY